Qty:

150 Um:

Each

: CROSSBOLT SPACER

: D32751

: N/A

:NIA

: 7/20/2007

- D3275 REV A1

Monday, 7/9/2007 3:43:55 PM

User:

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

Material

**Due Date** 

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 33429

**Estimate Number** 

: 10752

P.O. Number

Previous Run

AIU: : 7/9/2007

This Issue Prsht Rev.

First Issue

S.O. No. : NA

: MACHINED PARTS

: 32476

Checked & Approved By Comment

Written By

New issue KJ/JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

M6061T6T03125W058

ALUM. SEAMLESS TUBE

Comment: Qty.:

0.2799 f(s)/Unit Total:

41.9895 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) Ø0.313" x 0.058" wall

(M6061T6T0.3125W.058)I

dentify as D3275-1 Batch: M105212

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA469 and Dwg D3275

3.0

4.0

QC2

QC8

HARDINGE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

Comment: SECOND CHECK

PACKAGING RESOURCE #1

**PACKAGING** 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 46.

Dart Aerospace I	Lta
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	.oopas	<i>-</i>								
<b>W</b> /O:			WC	ORK ORDER CHANGE	S					
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							1			
Part No	:	PAR #:	Fault Cate	gory:						
NCR:		W	ORK ORDI	ER NON-CONFORMAN		C Closed:	Date: _			
			Corrective Action C			Section P				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

Date:

Monday, 7/9/2007 3:43:55 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 33429

Part Number: D32751

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace L	.td						
W/O:			V	VORK ORDER CHANGE	S			
DATE	STEP				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:	
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
¥					QA: N	/C Closed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMAN	ICE (NCR	)		
		Description of NC		Corrective Action Section	Section B		Annroval	Τ
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
		•						

		Description of NC		Corrective Action Section B			Approval Chief Eng			
DATE	STEP	Section A In		Initial       Action Description       Sig         Chief Eng       Chief Eng       Da		Sign & Section C		Approval QC Inspector		
*										
	1									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33429
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3./80		7		
0.025 - 0.030	N/A	1027				
45°	+/-0.01°	450		1.1		
Ø0.313	+0.010/-0.005	1317				
Ø0.197	+0.005/-0.000	1945				
0.058	Max = 0.0605 Min = 0.0555	De				
		· · · · · · · · · · · · · · · · · · ·				
				<del> </del>		
					·	
	]					

Measured by:	29/25	Audited by:	AZ	Pro	totype Approval:	N/A	
Date:	07/08/02	Date:	0108.03		Date:	N/A	

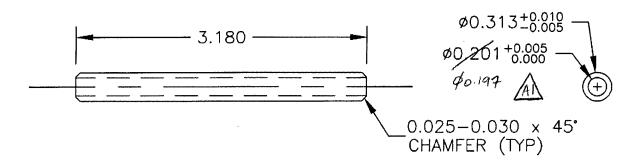
Rev	Date	Changé	Revised by	Approved
Α	04.10.19	New Issue	KJ/JLM LA	
В	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM	911/





DESIGN	P	DRAWN BY	DART AEROSPACE US	SA, INC.
CHECKE	D AA	APPROVED	DRAWING NO.	REV. A
	#	1	D3275	SHEET 1 OF 1
DATE	O-MINISTER & LINE HOLDE		TITLE	SCALE
04.03	3.10		CROSS BOLT SPACER	1:1
А		04.03.10	NEW ISSUE	
ALL	P	04.10.19	CHANGE MAT'L SPEC	

RELEASE 04.do.22



## D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

(REF DART SPEC. M60617670 313 W. 058 A)

2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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